



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3443-1

Job Sheet 200373



Part No: D3443-1

Job Qty: 12 pcs

Part Name: Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C A 05.11.14 New issue EC IPP Rev:B Removed Tumbling 08-09-08 JLM Verified By:EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	12 pcs	10/15/19	10/15/19	0.00	0.87	Bandsaw - 1	DJP R-11-12
110	HAAS 4 Axis - B4B	12 pcs	10/15/19	10/15/19	0.26	17.39	HAAS - 1 - B4B	DJP R-11-12
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
130	QC 8	12 pcs	10/15/19	10/15/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	



Container No: S230381



Part: D3443-1

Job No: 200373

Serial No/Batch: S230381

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 11/10/19

Plex 9/10/19 3:00 PM Dart.lajeunesse.marie

9/10/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

140 Packaging 3-1 - Stock - B4B 12 pcs

10/15/19 0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

DAS

74

9-89

NOV 20 2019

150 QC 21 - SA

12 pcs

10/15/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

DAS

21

9-89

Part Op 100 - Cut blank 2.400 " long
 Descriptions: 110 - (HAAS CNC Vertical Machine), Machine as per Folio FA587 Rev: ____ & Dwg D3443 Rev: NOV 20 2019
 130 - (QC8- Inspect parts - second check)
 140 - (Identify as per dwg & Stock Location: _____), LOCATION: WA001-5
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B2.500X1.250	17-4 SS Bar 2.500 x 1.250	2.4000 ft (.2 ea)	100-Bandsaw - 1	FM135447

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-B2.500X1.250	2	16	0

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug	1.000inches ± 0.010	1.010 0.990	1.000	
2	Lug	0.342inches ± 0.005	0.342 0.337	0.339	
3	Lug	0.329inches ± 0.010	0.339 0.319	0.329	
4	Lug	0.500inches ± 0.005	0.500 0.495	0.500	
5	Lug	2.210inches ± 0.030	2.240 2.180	2.216	
6	Lug	0.656inches ± 0.001	0.656 0.655	0.655	
7	Lug	0.625inches ± 0.010	0.635 0.615	0.627	
8	Lug	0.950inches ± 0.030	0.980 0.920	0.943	
9	Lug	2.230inches ± 0.010	2.240 2.220	2.228	
10	Lug	0.229inches ± 0.010	0.239 0.219	0.229	
11	Lug	0.370inches ± 0.010	0.380 0.360	0.369	
12	Lug	0.525inches ± 0.010	0.535 0.515	0.525	
13	Lug	0.524inches ± 0.010	0.534 0.514	0.524	
14	Lug	0.390inches ± 0.010	0.400 0.380	0.385	
15	Lug	1.048inches ± 0.010	1.058 1.038	1.048	
16	Lug	0.050inches ± 0.000	0.050 0.050	0.05	
17	Lug	45.000Degrees ± 0.500	45.500 44.500	45°	
18	Lug	0.032inches ± 0.010	0.042 0.022	0.032	
19	Lug	0.470inches ± 0.010	0.480 0.460	0.470	
20	Lug	0.165inches ± 0.010	0.175 0.155	0.162	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS			Engineering Water Jet Supplier Quality			
Date :	Sequence #:	QTY Affected :			MRB (QS1042)						
Description Work Order Deviation		Disposition									
Root Cause Operator _____ Manufacturing Process _____ Equip/Tooling _____ Handling/Preservation _____ Material _____ Product Improvement _____ Process Improvement _____ Human Factors _____		FAULT CATEGORY									
		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
		Completed By _____									
		Lead hand / Supervisor _____									
		QC / QA Coordinator _____									